

Work Order ID 111790

January-22-14 10:38:11 AM

\*111790\*

Page 1

Item ID: D3584-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Web

Start Date: 1/22/14 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 2/05/14 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 14-01-22

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3584	Rev A

100 \*100\* Skidtubes 0.00

Skidtubes Memo 0.00  
1-Cut to Length as per Dwg D3584  
2-Drill Pillot Holes using DT8960 Drill Jig  
3-Open pilloots to 1.000" as per Dwg D3584  
4-Deburr

2 d 14-01-22 DCL

110 \*110\* QC5- Inspect part completeness to step on W/O 0.00

Quality Control Memo 0.00

D CL 14-1-22

120 \*120\* HandFinish Chemical Conversion Coat per QSI005 4.1 0.00

Hand Finishing Memo 0.00

2 d 14-1-22 DCL

DQA:

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: \_\_\_\_\_

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

**DISPOSITION**

Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved

**AGAINST DEPARTMENT/PROCESS**

Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General			
Bending	Bend			
Centre Not Concentric	BOM/Route	Folio/Program		
Cracks	Broken/Damage/Defect	Grain		
Crimp/Kink/Ripple/Wave	Burrs	Hardware		
Cuffs	Contamination	Inspection Incomplete/Unqualified		
Crushing	Countersink	Instructions Incomplete/Unclear		
Heat Treat	Cut Too Short	Misaligned/off center		
Inspection Strip in Tube	Drawing	Mislabeled		
Marks/Chatter	Drill Holes	Misread		
Turning Sequence	Finish	Off-set		
Wave/Twist in Tube	Fit/Function	Out of Calibration		
		Out of Sequence		



DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____ Part No. _____ NCR No. _____	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
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	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

# Picklist Print

January-22-14 10:38:15 AM

Page 1

Work Order ID: 111790

\*111790\*

Parent Item: D3584-1

\*D3584-1\*

Parent Item Name: Web

Start Date: 1/22/14

Required Date: 2/05/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-125		Manufactured	No			110	Each	46.0000	1	2		**	

\*D2963-125\*

105 I Beam Extrusion

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	46	
	46	

28673

2 14-01-22 D6C

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

**DISPOSITION**

Rework  
Scrap  
Use-as-is  
Suspected Unapproved

Skid-tube  
Machining  
Thermoforming  
Large Fab

**AGAINST DEPARTMENT/PROCESS**

Crosstube  
Small Fab  
Finishing  
Composite

Water Jet  
Prod. Eng. Coor.  
Rec/Store/Packaging  
Supplier

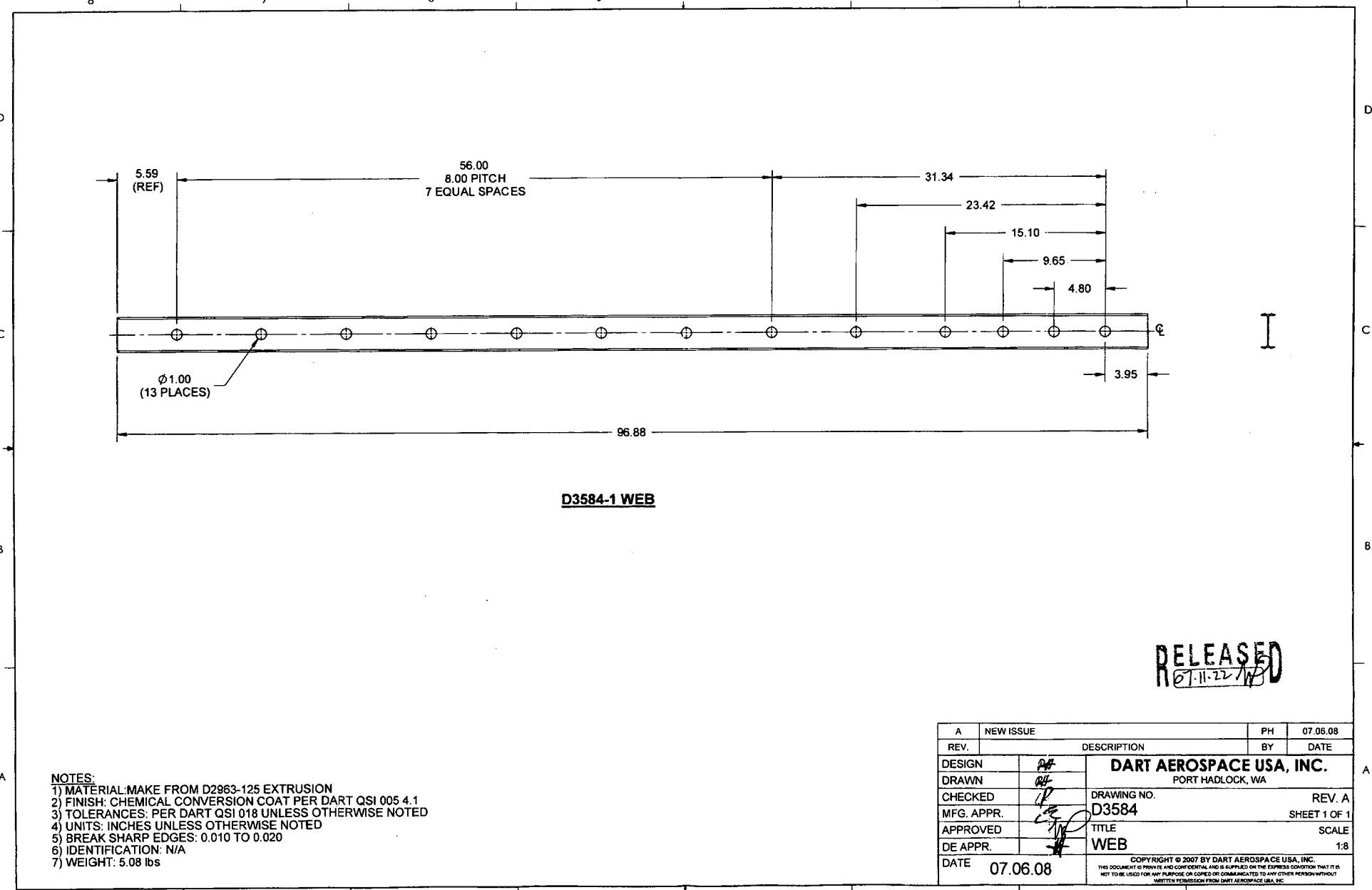
Engineering  
Quality  
Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<table border="0"> <tr> <td colspan="5" style="text-align: center;"><b>General</b></td><td colspan="5"></td></tr> <tr> <td><input type="checkbox"/> Bend</td><td><input type="checkbox"/> Folio/Program</td><td><input type="checkbox"/> Outside Dimensions</td><td><input type="checkbox"/> Pressure/Forced</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> BOM/Route</td><td><input type="checkbox"/> Grain</td><td><input type="checkbox"/> Over/Under tolerance</td><td><input type="checkbox"/> Set-up</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Broken/Damage/Defect</td><td><input type="checkbox"/> Hardware</td><td><input type="checkbox"/> Part Incorrect</td><td><input type="checkbox"/> Temperature/Cure</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Burrs</td><td><input type="checkbox"/> Inspection Incomplete/Unqualified</td><td><input type="checkbox"/> Part Lost/Missing</td><td><input type="checkbox"/> Weld</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Contamination</td><td><input type="checkbox"/> Instructions Incomplete/Unclear</td><td><input type="checkbox"/> Part Moved</td><td><input type="checkbox"/> Wrong Stock Pulled</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Countersink</td><td><input type="checkbox"/> Misaligned/off center</td><td><input type="checkbox"/> Positioned Wrong</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Cut Too Short</td><td><input type="checkbox"/> Mislabeled</td><td><input type="checkbox"/> Power Loss/Surge</td><td><input type="checkbox"/> Other</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Drawing</td><td><input type="checkbox"/> Misread</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Drill Holes</td><td><input type="checkbox"/> Off-set</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Finish</td><td><input type="checkbox"/> Out of Calibration</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td><input type="checkbox"/> Fit/Function</td><td><input type="checkbox"/> Out of Sequence</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> </table>	<b>General</b>										<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced							<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up							<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure							<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld							<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled							<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong								<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other							<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread									<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set									<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration									<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence								
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111790  
MLJ  
14-01-22



DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order:					<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No.					Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering			
NCR No.					Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>				Quality
					Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
					Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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<b>FAULT CATEGORY</b>												
Landing Gear	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube			<b>General</b>								
				<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced	
				<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up	
				<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure	
				<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld	
				<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled	
				<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>		
				<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other	
				<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>				
				<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>				
				<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>				
				<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>				